

Work Order ID 148251

Tuesday, June 28, 2016 8:57:51 AM

148251

Page 1

Item ID: D3389-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web
 Start Date: 6/17/2016 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 6/27/2016 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **JUL 04 2016** Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3389	Rev D

100 0.00

100 Skidtubes

Skidtubes Memo 0.17

Skidtubes

- 1- Pick D2500-3-100
- 2- Deburr
- 3- Locating from deburred end, drill pilot holes using DT8785 as per dwg D3389. Scribe cut line.
- 4- Cut to finished length
- 5- Open holes to finished size as per dwg D3389
- 6- Deburr

110 0.00

110 QC6- Inspect dimensions to drawing

QC Memo 0.00

Quality Control

5 16-08-15 RL

5 16-08-23

DAS 18 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																							
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																								OTHER :																																							

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Page 2

Item ID: D3389-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web

Start Date: 6/17/2016 Start Qty: 5.00

5

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120 Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.17

Hand Finishing

(X5) 16-09-08
BEB

DAS
18
3-89

130 QC7-Inspect Chemical Conversion Coat

0.00

130

QC

Memo

0.01

Quality Control

5 0 16-09-08

140 Identify as per dwg & Stock Location: LG002

0.00

140

Packaging

Memo

0.01

Packaging

LOCATION : LG002

5 0 BE
16-09-08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
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Page 3

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC21- Final Inspection - Work Order Release	0.00							
150							DAS 21 9-89		SEP 09 2016
QC	Memo	0.08							
Quality Control							DAS 21 9-89		SEP 09 2016

DQA: _____ Date: _____



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Picklist Print

Tuesday, June 28, 2016 8:57:50 AM

Page 1

Work Order ID: 148251

148251

Parent Item: D3389-1

D3389-1

Parent Item Name: Web

Start Date: 6/17/2016

Required Date: 6/27/2016

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A05.08.31New issueKJ/JLM
IPP Rev:B 06-02-08 As per Rev C JLM
IPP Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2500-3-100

Manufactured

No

100

Each

36.0000

1

5

D2500-3-100

Ext'n - I' Beam Web 4"

Location

Loc Qty

Loc Code

HALL

36

133211

36

147804 RL

5

16-06-15
R-L

DQA: _____ Date: _____

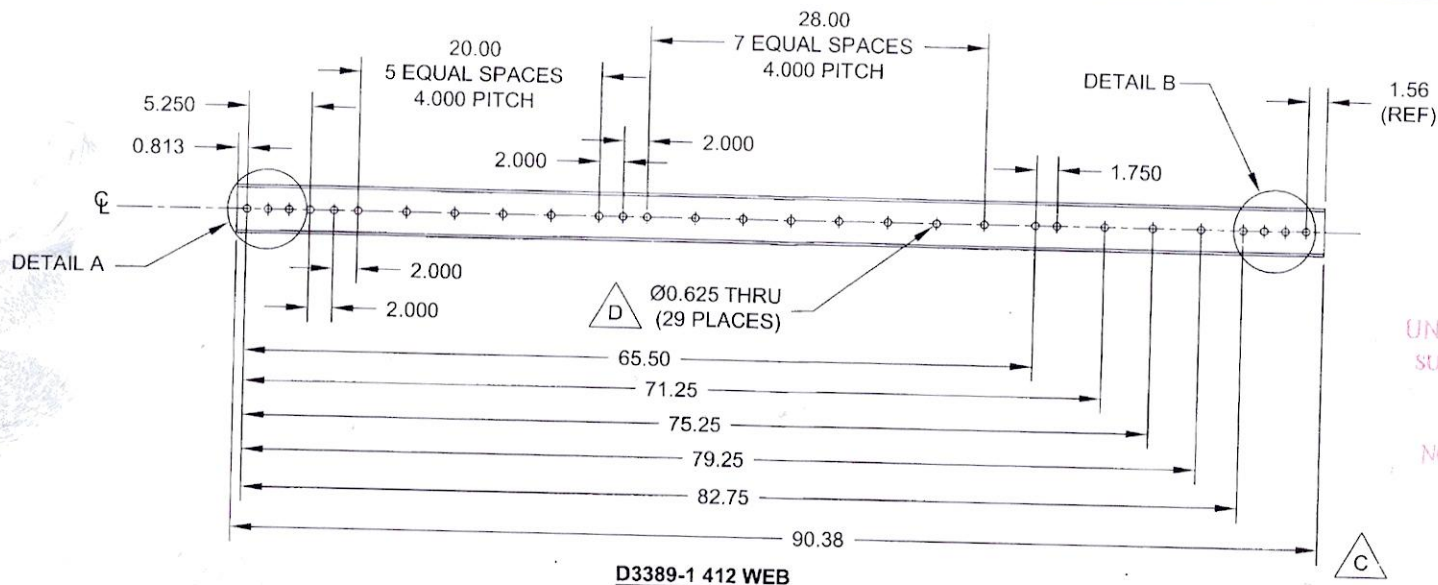


WORK ORDER NON-CONFORMANCE / UPDATE

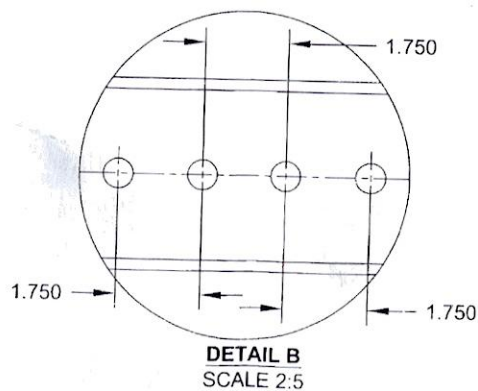
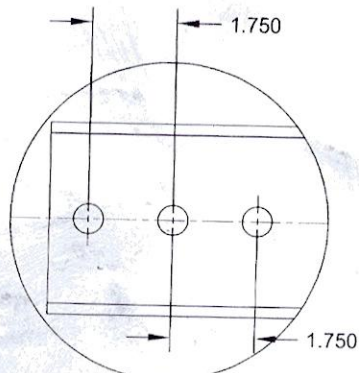
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OTHER :					



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 148251 MJS
16-07-04



NOTES:

- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06 MJS

DESIGN	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
DRAWN	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
CHECKED	UPDATE DIMENSIONING	PH	05.06.13
MFG. APPR.	NEW ISSUE	PH	05.02.07
APPROVED	REV.	BY	DATE
DE APPR.	DESCRIPTION		
DATE	07.10.09		

DART AEROSPACE USA, INC
PORT HADLOCK, WA

DRAWING NO. D3389
TITLE 412 WEB
SCALE 1:10

REV. D
SHEET 1 OF 1

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